

Work Order ID 83545

April-19-12 11:25:39 AM

83545

Page 1

Item ID: D2535

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spring

Start Date: 19/04/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/04/19

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2535

Rev A

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 16773 Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring12-04-19

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

12/4/27 (100)

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Check dims to dwg

5-7/2/30ECW

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start ***NS1***

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Start Date: 19/04/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *5ay.* 0.00

130

Packaging

Memo

0.00

100x

Sp

Packaging

12-05-02.

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/5/11

MF 12-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-19-12 11:25:42 AM

Page 1

Work Order ID: 83545

83545

Parent Item: D2535

D2535

Parent Item Name: Spring

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP A99.04.19New Issue (From hand written IPP)DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2535P		Purchased	No			100	Each	0.0000	1	100			

D2535P

Spring

**

1014/2/27 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

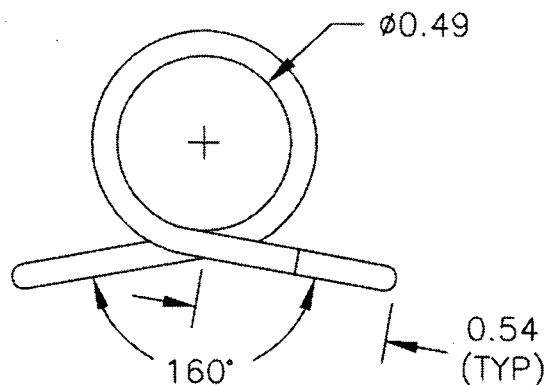
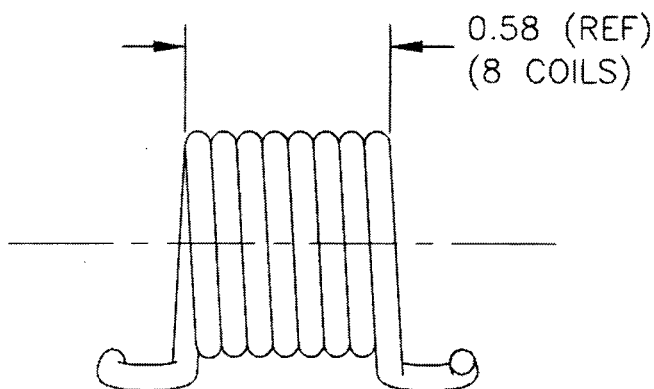
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NOTE: Date & initial all entries

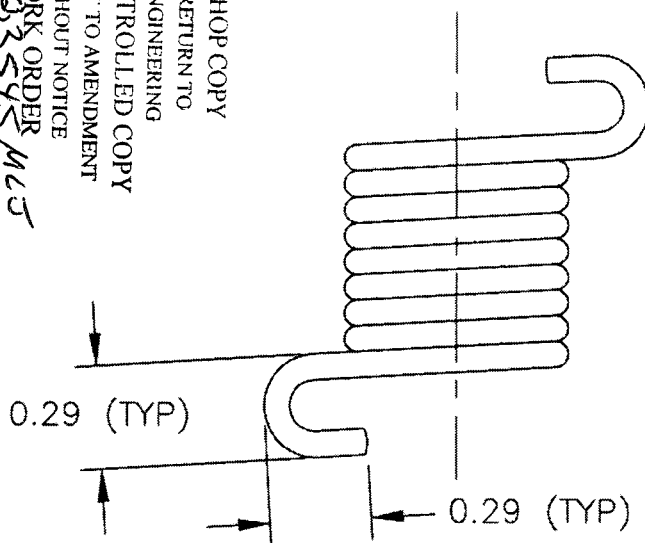


DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08	TITLE SPRING SPEC CONTROL		SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 03595 MJS
12/07/19



SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO15773**

Purchase Order Date 4/19/2012

PO Print Date 4/19/2012

Page Number 1 of 1

Order From :

VC-VIC002

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

Contact Name		Buyer	Brigitte Golden
Vendor Phone	866 230 5312	Requisition Nbr	
Vendor Fax	866 230 5338	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2535P	Spring	5/4/2012 Yes	100.00 Each	FedEx Overnigh	\$4.5600	\$456.00

Special Inst: As per DWG: D2535
Rev: A
B83545

PO Total: \$456.00

Change Nbr: 1

Change Date: 4/19/2012

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



convenient. consistent. correct.

PACKING SLIP

24620

#2, 6104 - 82 Ave.
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

BILL TO: Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

SHIP TO: Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

DATE		ORDER No.		SHIP VIA	
Apr 26, 2012		PO16773		FedEx	
QUANTITY	DESCRIPTION			UNIT	AMOUNT
100	VIC 1533 D2535P Spring - Torsion				
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd	DATE: 4/30/2012
PART/DRAWING #: D2535P	PO # <u>PO16773</u>
SPRING DESCRIPTION: Torsion	QUANTITY: 100

8/26/30

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS 302	Yes	
Material diameter	0.07	0.072	
Coil I.D.	0.490	0.491	
Coil O.D.			
Number of Coils	8 ref	7.95	
Free Length			
Helix	RHW	RHW	
End type	per dwg.	Yes	
Deburr End			

COMMENTS

Mill Certificate attached: No
Material Heat Number: E31404

Inspected by: *Chris Burrows*